



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

004948
AUG 08 2018
Ph

D119-827-011
Job Sheet 181645



Part No: D119-827-011

Job Qty: 1 ea

Part Name: Tail Rotor Pedal Lockout



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/2/18

Job Tracking No:

Due Date: 8/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B 13-01-09 REV B JLM
VERIFIED:DD IPP REV:C 12.10.16 as per CHG002 (ecn 13-538) DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/29/18	8/29/18	0.00	0.00	Start Up Stores/Pkg-1		AUG 10 2018
110	Packaging	1 pcs	8/29/18	8/29/18	0.00	0.00	Packaging1-1		JRB
120	QC	1 pcs	8/29/18	8/29/18	0.00	0.00	QC4		JRB
130	Packaging	1 pcs	8/29/18	8/29/18	0.00	0.00	Packaging3-1		AUG 14 2018
135	DC	1 pcs	8/29/18	8/29/18	0.00	0.00	DC		21
140	QC21-FG	1 Ea	8/29/18	8/29/18	0.00	0.00	QC21		9-89

Part Op 130 - Identify and pack for shipping as per PPP D119-827-011
Descriptions: 135 - Photocopy bluefile & type labels per PPP D119-827-011 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-11A	Bolt	2 Ea (2 ea)	90-Start up Operation	5070193
D4703-041	Lock Pin Assembly	2 Ea (2 ea)	90-Start up Operation	5090304
D4704-041	Expandable Pin Assembly	1 Ea (1 ea)	90-Start up Operation	5075091
D4710-1	Spacer	1 Ea (1 ea)	90-Start up Operation	5042139
D4721-1	Decal	1 Ea (1 ea)	90-Start up Operation	5040348
MS14144L4	Nut	2 Ea (2 ea)	90-Start up Operation	514136835
MS24665-153	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	F107139
NAS1149D0416J	Washer	2 Ea (2 ea)	90-Start up Operation	FM131511
NAS1149D0463J	Washer	8 Ea (8 ea)	90-Start up Operation	5089209
NAS6604D16	Bolt	2 Ea (2 ea)	90-Start up Operation	5007045

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-11A	2	288	0
	D4703-041	2	6	0
	D4704-041	1	1	0
	D4710-1	1	1	0
	D4721-1	1	4	0
	MS14144L4	2	11	0
	MS24665-153	2	510	0
	NAS1149D0416J	2	2,918	0
	NAS1149D0463J	8	10,343	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																
Date: _____	St _____	QTY Effective: _____			MRB (QSI042) Approval																																																																													
Description Work Dart Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K6A 1K7 CANADA TEL: 1 813 832-8200 Email: sales@dartaero.com www.dartaero.com DART AEROSPACE Container No: S101185 Part: D119-827-011 Job No: 181645 Serial No/Batch: S101185 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: FAA STC SR02258SE 17/06/2016, STC SH14-22 Issue 1, EASA S7																																																																																		
Root Cause <table border="0" style="width: 100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> <table border="0" style="width: 100%;"> <tr><td>☐ Crimp/Kink/Ripple/Wave</td><td>☐ Inspection</td><td>☐ Positioned Wrong</td></tr> <tr><td>☐ Cuffs</td><td>☐ Contamination</td><td>☐ Outside Dimensions</td></tr> <tr><td>☐ Crushing</td><td>☐ Countersink</td><td>☐ Over/Under tolerance</td></tr> <tr><td>☐ Heat Treat</td><td>☐ Cut Too Short</td><td>☐ Part Incorrect</td></tr> <tr><td>☐ Wave/Twist in Tube</td><td>☐ Instructions Incomplete/Unclear</td><td>☐ Part Lost/Missing</td></tr> <tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Part Moved</td></tr> <tr><td></td><td></td><td>☐ Drawing</td></tr> <tr><td></td><td></td><td>☐ Finish</td></tr> <tr><td></td><td></td><td>☐ Misread</td></tr> <tr><td></td><td></td><td>☐ Turning Sequence</td></tr> </table>					Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	☐ Crimp/Kink/Ripple/Wave	☐ Inspection	☐ Positioned Wrong	☐ Cuffs	☐ Contamination	☐ Outside Dimensions	☐ Crushing	☐ Countersink	☐ Over/Under tolerance	☐ Heat Treat	☐ Cut Too Short	☐ Part Incorrect	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Part Moved			☐ Drawing			☐ Finish			☐ Misread			☐ Turning Sequence
Environment	☐	No Re-verification	☐																																																																															
Design	☐	Operator	☐																																																																															
Doc/Data	☐	Offset/Setup	☐																																																																															
Equip/Tooling	☐	Supplier	☐																																																																															
Handling/Pre	☐	Training	☐																																																																															
Material	☐	Use for Testing	☐																																																																															
Internal Transport	☐	Poor Information	☐																																																																															
Tribal Knowledge	☐	Rushing	☐																																																																															
LOA	☐	Product Improvement	☐																																																																															
Substation	☐	Process Improvement	☐																																																																															
Past Expiry Date	☐	Manufacturing Process	☐																																																																															
Misidentified	☐	Past Due	☐																																																																															
☐ Crimp/Kink/Ripple/Wave	☐ Inspection	☐ Positioned Wrong																																																																																
☐ Cuffs	☐ Contamination	☐ Outside Dimensions																																																																																
☐ Crushing	☐ Countersink	☐ Over/Under tolerance																																																																																
☐ Heat Treat	☐ Cut Too Short	☐ Part Incorrect																																																																																
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing																																																																																
☐ Marks/Chatter	☐ Drill Holes	☐ Part Moved																																																																																
		☐ Drawing																																																																																
		☐ Finish																																																																																
		☐ Misread																																																																																
		☐ Turning Sequence																																																																																
OTHER: _____																																																																																		

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

REFERENCE ONLY**4.0 PARTS LIST**

QTY -011	QTY -013	Part Number	Description
X		D119-827-011	TAIL ROTOR PEDAL LOCKOUT
	X	D109-827-013	TAIL ROTOR PEDAL LOCKOUT
2		D4703-041	LOCKOUT PIN ASSY
	1	D4703-045	LOCKOUT PIN ASSY
1		D4704-041	EXPANDABLE PIN ASSY
	1	D4704-043	EXPANDABLE PIN ASSY
1	1	D4710-1	SPACER
1	1	D4721-1	DECAL
	2	D5481-041	PLUG ASSEMBLY
2		AN4-11A	BOLT
	2	AN4H11A	BOLT
2		MS14144L4	NUT
2		MS24665-153	COTTER PIN
2		NAS1149D0416J	WASHER
8	2	NAS1149D0463J	WASHER
2		NAS6604D16	BOLT

5.0 WEIGHT AND BALANCE

Installation	Weight	Longitudinal		Lateral	
		Arm	Moment	Arm	Moment
D119-827-011 (A109/A119) <i>Tail Rotor Pedal Lockout</i>	0.52 lb 0.23 kg	32.6 in 0.83 m	16.9 in-lb 0.19 m-kg	-13.1 in -0.33 m	-6.8 in-lb -0.08 m-kg
D119-827-011 (206/407) <i>Tail Rotor Pedal Lockout</i>	0.52 lb 0.23 kg	33.0 in 0.84 m	17.2 in-lb 0.19 m-kg	-12.5 in -0.32 m	-6.5 in-lb -0.07 m-kg
D109-827-013 (AW109SP) <i>Tail Rotor Pedal Lockout</i>	0.54 lb 0.24 kg	32.6 in 0.83 m	17.6 in-lb 0.20 m-kg	-13.1 in -0.33 m	-7.1 in-lb -0.08 m-kg

REFERENCE ONLY

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL

• COPYRIGHT © 2012 BY DART AEROSPACE USA INC. •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA INC.

Revision: **E**
 Date: 17.02.03

Change Record

PAGE 1 OF 1

Part Number: D119-827-011

Description: TAIL ROTOR PEDAL LOCKOUT[illegible]